

Date: Wednesday, 5/31/2006 7:39:40 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STA 84 BRACKET
Job Number	: 27301		
Estimate Number	: 11034		
P.O. Number	: N/A	Part Number	: D28031
This Issue	: 5/31/2006 S.O. No. : N/A	Drawing Number	: D2803 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: B
Previous Run	: 25928	Material	: N/A
Written By	: <i>SEA</i> <i>COMMENT: ECDW</i>	Due Date	: 6/18/2006 Qty: 10 Um: Each
Checked & Approved By	: <i>06-01-31 N</i>		
Comment	: Est. A00.14.06 New Issue EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0500X10000	6061-T6 Bar .50" x 10.0"
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Comment: Qty.: 2.0125 f(s)/Unit Total: 20.1254 f(s)
 6061-T6 Bar .50" x 10.0"

Material: 6061-T6 bar 10.00" x 0.50"

Batch: *1100285**06 06 06*

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
 Cut blanks per template DT8533

*WATERJET**06 06 06**(10)*

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Machine as per folio FA102

*J.F. 06/06/08**(10)*

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*J.F. 06/06/08**(10)*

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

*J.G. 06/06/08**10*

6.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
 Tumble & Deburr

*J.F. 06/06/08**(10)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA:  Date: 06/06/15

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Wednesday, 5/31/2006 7:39:40 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STA 84 BRACKET

Job Number: 27301

Part Number: D28031

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC5

INSPECT WORK TO CURRENT STEP



06-06-09 (10)

Comment: INSPECT WORK TO CURRENT STEP

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SAN 06:06:10 (10)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 57156

06/12/6 (16)

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/06/13 (10)

Job Completion



06-06-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD		Work Order:	27301
Description: Bracket		Part Number:	D2803-1
Inspection Dwg: D2803	Rev: B	Page 1 of 1	



FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
12.625	+/-0.010					
Ø0.757	+0.005/-0.000	Ø0.758	—			
Ø0.191	+0.005/-0.000	Ø0.192	—			
Ø0.507	+0.000/-0.001	Ø0.5065	—			
13.558	+/-0.010	13.558	—			
Ø0.507	+0.000/-0.001	Ø0.5066	—			
12.411	+/-0.010	12.411	—			
2.654	+0.000/-0.001	2.654	—			
0.437	+0.000/-0.001	0.437	—			
1.420	+/-0.001	1.420	—			
6.933	+/-0.010	6.933	—			
0.250	+/-0.010	0.249	—			
0.875	+0.000/-0.001	0.8749	—			
0.250	+0.000/-0.005	0.250	—			
0.125	+/-0.010	0.125	—			
0.125	+/-0.010	0.126	—			
0.125	+/-0.010	0.129	—			
0.125	+/-0.010	0.129	—			
0.500	+/-0.010	0.504	—			
0.562	+/-0.010	0.570	—			
0.188	+/-0.010	0.189	—			

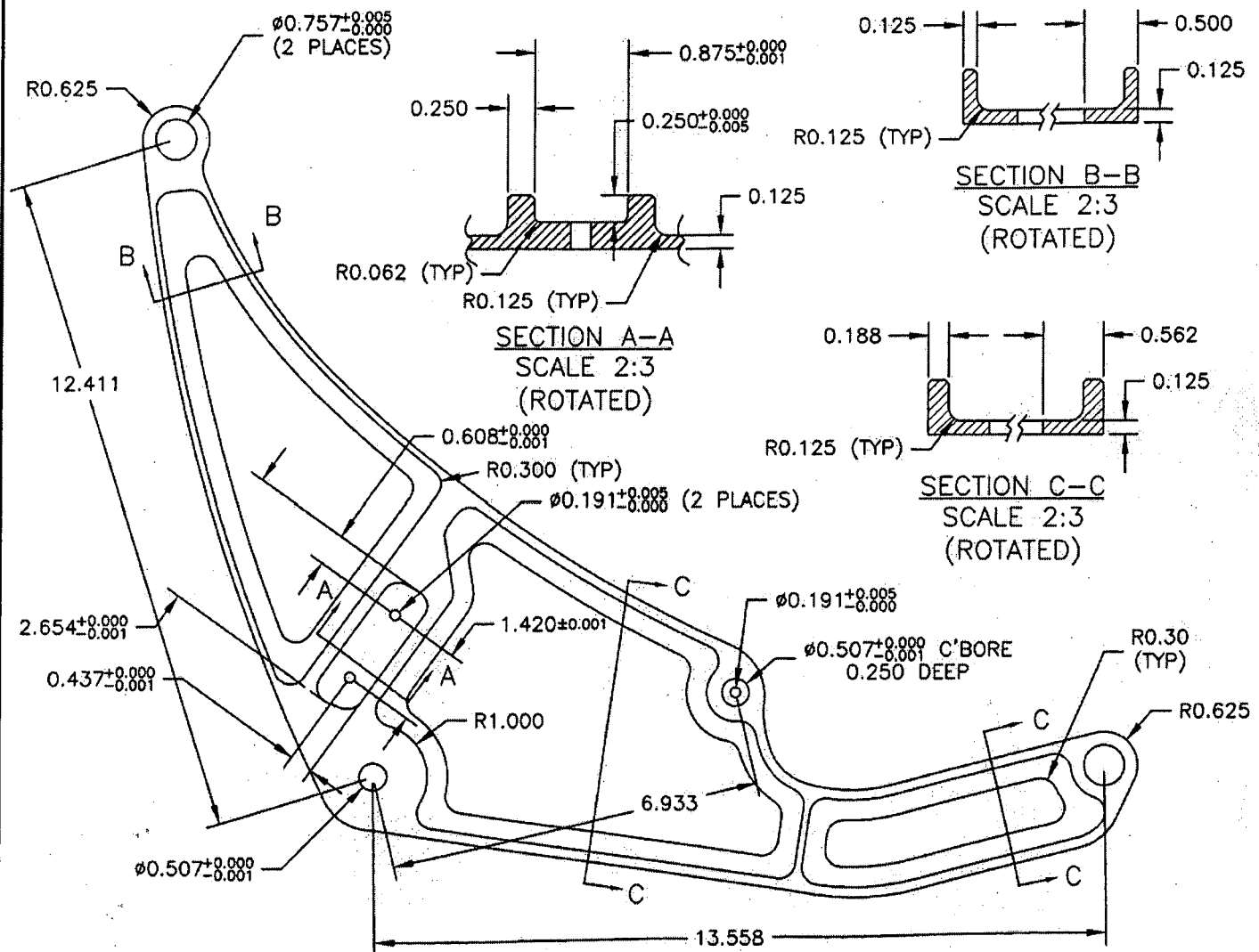
Measured by:	<i>ML</i>	Audited by:	<i>En</i>	Prototype Approval:	N/A
Date:	06/06/07	Date:	06/06/07	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.25	New Issue	KJ/JLM <i>[Signature]</i>	<i>[Signature]</i>

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D2803	REV. B SHEET 1 OF 2
DATE 04.11.22		TITLE STA 84 BRACKET	SCALE 1:3
A	00.11.07	NEW ISSUE	
B	04.11.22	ADD CUTOUTS & -043/-044	

RELEASED

05.03.11



D2803-1 BRACKET (SHOWN). D2803-2 BRACKET (OPPOSITE)

- 1) MACHINE PER DRAWING FILE "D2803.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WITHOUT NOTICE
WORK ORDER
NO. 27301

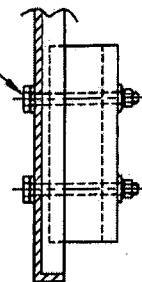
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DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2803	REV. B SHEET 2 OF 2
DATE 04.11.22	TITLE STA 84 BRACKET		SCALE 1:3

AN3C16A BOLT (1)
NAS1515H3 WASHER (2)
MS21043-3 NUT (1)
INSTALL BOLT WITH LPS-3 CORROSION
INHIBITOR (ENSURE NO LPS-3 ON THREADS)
(2 PLACES)

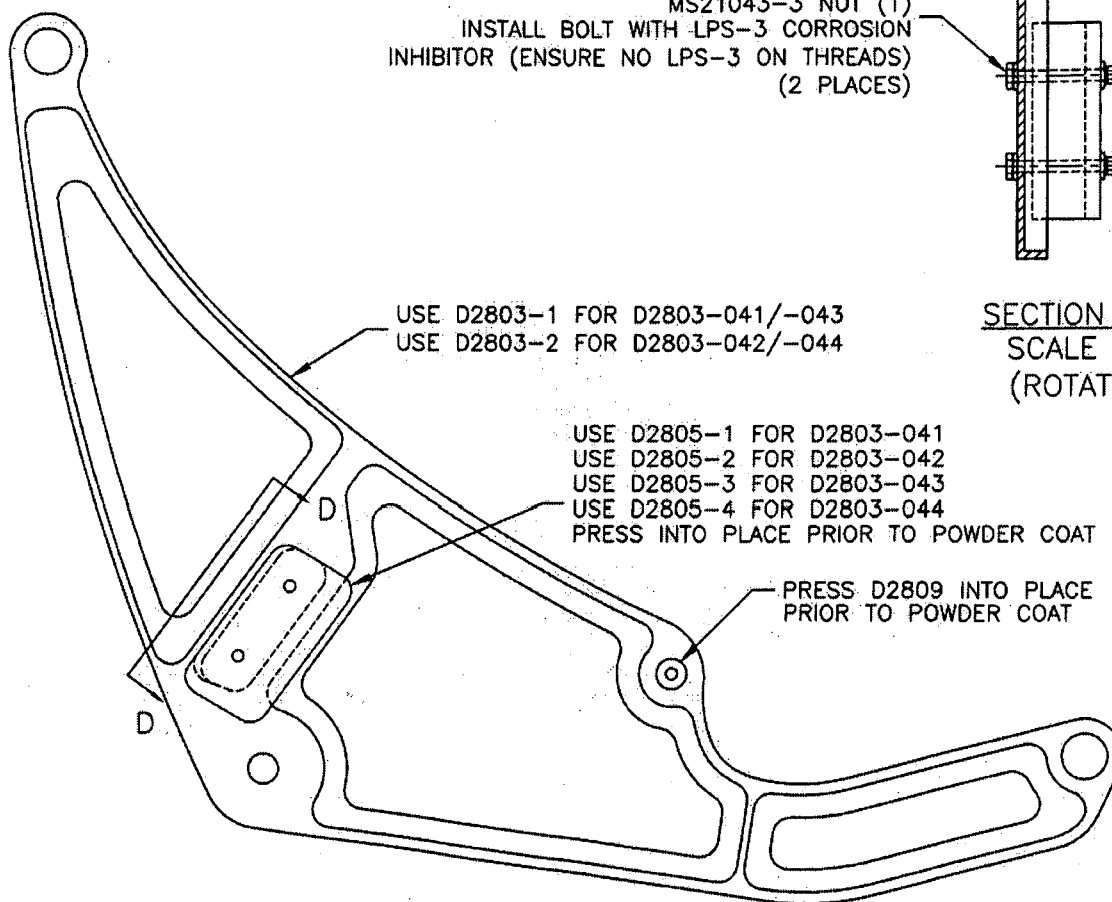


SECTION D-D
SCALE 1:3
(ROTATED)

USE D2803-1 FOR D2803-041/-043
USE D2803-2 FOR D2803-042/-044

USE D2805-1 FOR D2803-041
USE D2805-2 FOR D2803-042
USE D2805-3 FOR D2803-043
USE D2805-4 FOR D2803-044
PRESS INTO PLACE PRIOR TO POWDER COAT

PRESS D2809 INTO PLACE
PRIOR TO POWDER COAT



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WITHOUT NOTICE

WORK ORDER

NO. 27301

D2803-041/-043 BRACKET ASS'Y (SHOWN)
D2803-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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